

Date: Thursday, 5/3/2007 11:39:27 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASS'Y
Job Number : 32207	
Estimate Number : 12522	
P.O. Number : <u>N/A</u>	Part Number : D35311
This Issue : 5/3/2007 S.O. No. : <u>N/A</u>	Drawing Number : UNDER REVIEW <sup>CB</sup> 07.05.04
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : <u>N/A</u>
Previous Run : 31171	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 5/28/2007
Checked & Approved By : <u>[Signature]</u>	Qty: 3 Um: Each
Comment : Est Rev: A New Issue 06-09.06 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.3972 sf(s)/Unit Total : 1.1916 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: M 100742

SAD 07/05/09

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3531

Dwg Rev: prel

Prog Rev: prel

SAD 07/05/09

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/09

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 07.05.09

3

5.0	BRAKE NC	NC BRAKE
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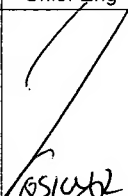







Comment: NC BRAKE

Bend as per Dwg D3531

SAD 07/05/1183

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/09	2.0	1 part were Scrap because of the offset (One part)		Scrap and destroy and replace	SAM 07/05/09	 07/05/09	 051042	 07/05/09
07/05/09	2.0	Dimension were wrong on Program (One part)		Scrap and destroy and replace	SAM 07/05/09	 07/05/09	 051042	 07/05/09

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:39:28 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASS'Y

Job Number: 32207

Part Number: D35311

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*07/05/23 (3)*



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*FDL / DK 07/05/23 (3)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



**ENGINEERING  
APPROVAL**

*07/05/24*



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57115

*07/05/24 (3)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/05/24 (3)*

Job Completion



*07/05/24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

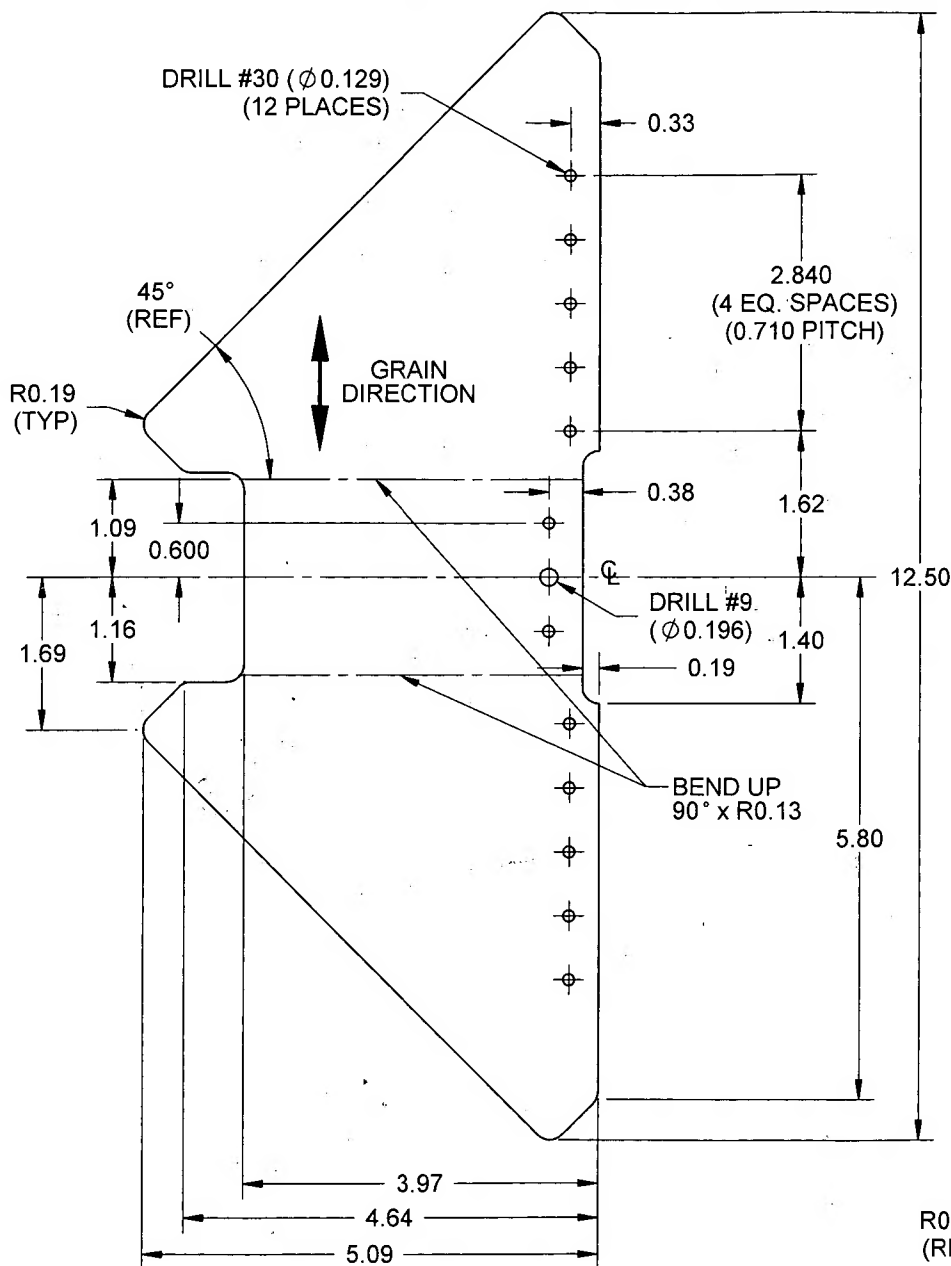
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3531	REV. A SHEET 2 OF 3
DATE 07.01.10	TITLE BRACKET ASSEMBLY		SCALE 1:2

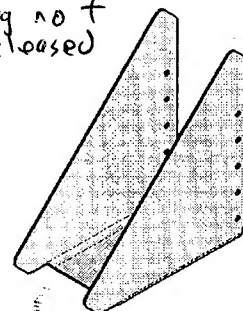


**D3531-1F FLAT PATTERN**

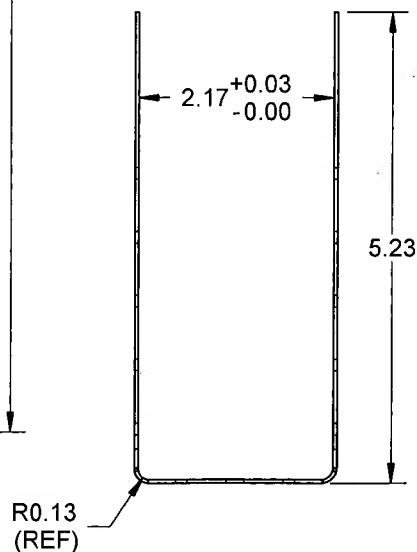
**UNDER REVIEW**

07.05.01 CB

dwg not released



**ISOMETRIC VIEW  
SCALE 1:4**



**D3531-1 BRACKET**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$

STOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32207

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DART AEROSPACE LTD		Work Order: 32207
Description: BRACKET ASSY "P"		Part Number: D353101
Inspection Dwg: D35311 Rev: PREL		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	12.50	$\pm 0.030$	12.49	✓		Vern height gauge	
B	0.600	$\pm 0.030$	0.598	✓		Vern	
C	3.97	$\pm 0.030$	3.98	✓		height gauge	
D	4.64	$\pm 0.030$	4.63	✓		height gauge	
E	9.09	$\pm 0.030$	9.09	✓		Vern	
F	6.80	$\pm 0.030$	5.81	✓		height gauge	
G	1.40	$\pm 0.030$	1.42	✓		height gauge	
H	1.62	$\pm 0.030$	1.64	✓		height gauge	
I	0.38	$\pm 0.030$	0.38	✓		Vern	
J	0.19	$\pm 0.030$	0.19	✓		height gauge	
K	0.33	$\pm 0.030$	0.33	✓		Vern	
L	Ø0.129	$+0.005/-0.001$	Ø0.132	✓		Vern	
M	Ø0.196	$+0.005/-0.001$	Ø0.196	✓		Vern	
N	0.040	$\pm 0.010$	0.038	✓		Vern	
O	2.840	$\pm 0.010$	2.843	✓		Vern	
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: JAL	Audited by: EG	Prototype Approval: N/A		
Date: 07/05/08	Date: 07-05-09	Date: N/A 07-05-09		
Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	